Work	Örder ID 2010 8:44.	57161
March 24,	2010 8:44:	19 AM
T4:ID:	D206	(42.241



Page 1

Item ID:

D206-642-341

Accept

Setup Start



Revision ID: Item Name:

Replacement Skidtube

Start Date:

24/03/2010

Start Qty: 1.00

Required Date: 07/04/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference: Approvals:

Process Plan:

Date: 10-3-24 Tooling:

Date:

SPC (Y/N):

Date: Date: Run Start

Reject

Qty

Stop

Stop



Sequence ID/ **Work Center ID** Operation Description Set Up/ **Run Hours** Draw Number Draw Plan Rev. Code Accept Qty

Reject

Insp. Number Stamp

Draw Nbr **Revision Nbr** D2650



Document Control

DOCUMENT CONTROL

Memo

0.00

0.00

Photocopy bluefile and create labels per PPP D206-642-341

CHG003

			_							• •	
Dart Ae	rospace	Ltd									
W/O:			··	WO	RK ORDER CHA	ANGES			<u>.</u>	. 1	
DATE	STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
		•									·
Part No):	P	AR #:	Fault Categ	ory:	NCR	: Yes	No DQ	A:	_ Date: _	•
	Re	esolution:	1	Disposition	:	QA:	N/C CI	sed:		Date: _	
NCR:				WORK ORDE	R NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description	of NC	Corrective Action Section E			Verification			Approval	Approva
DAIL	SILF	Section A		Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date	Secti		Chief Eng	QC Inspecto
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		-									

Page 2

Stop

Stop

Reject

Insp.

Number Stamp

March 24, 2010 8:44:19 AM Item ID: Accept D206-642-341 Setup Start **Revision ID:** Replacement Skidtube Item Name: **Start Date:** 24/03/2010 Start Qty: 1.00 **Cust Item ID: Required Date:** 07/04/2010 Reg'd Oty: 1.00 **Customer:** Reference: Run Start **Tooling:** Process Plan: Approvals: Date: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject **Work Center ID** Description **Run Hours** Number Rev. Code Oty Otv 0.00 Skidtubes 0.00 Skidtubes Memo Skidtubes 1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650 3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as A/R - Aluminum Rod - M112507/ M113207 BE 10-3-30 4-Grind weld flush to cap on top surface only. 5-Cut aft end to lenght as per dwg D2650 6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312" 7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297". 8-Open Aft Cap Hole using #6 Drill Bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

10-3-30

W/O:			WORK ORDER CHANGES								
DATE	STEP		PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		·									
Part No	:	P/	AR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	Date:		
			I		ion:						
NCR:			1	WORK OR	DER NON-CONFORMA	ANCE (NCF	R)				
DATE	STEP	Description	of NC	on B	Verific	cation		Approval			
DATE	SIEP	. Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Secti	ion C	Chief Eng	QC Inspector	
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Work Order ID 57161

Aarch 24, 2010 8:44:19 AM

Required Date: 07/04/2010



Page 3

Item ID:

D206-642-341

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

24/03/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference: Start Run Approvals: Process Plan: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Number Rev. Code **Qtv** Oty Number Stamp Chemical Conversion Coat per QSI005 4.1 0.00 M10/3/30 HandFinish 0.00 Memo

Skidtubes

Hand Finishing

Skidtubes

0.00

0.00

Memo

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

- 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)
- 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.
- 4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting Start Date: 10/3/3/ Time: 2 3 9 Finish Date: 10/3/3| Time: 10/3/3 A/R Sikaflex-291 4/2 4/3 Sikaflex expiry date: 2/3/3/3

M10/3/30

Dart Ae	rospace Li	td							,		,
W/O:				WO	RK ORDER CHAN	IGES	· .			1	•
DATE	STEP		PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No):	P	AR #:	Fault Categ	jory:	NCI	R: Yes	No DQ	A:	Date: _	
	Resolution:			Disposition	:	QA:	N/C CI	osed:		Date: _	
NCR:				WORK ORDE	R NON-CONFOR	MANCE	(NCF	l)			
DATE	0750	Description	of NC	f NC Corrective Action			Section B			Approval	Approve
DATE	STEP	Section A		Initial Chief Eng	Action Descriptio Chief Eng	n	Sign & Date	Verific Section		Chief Eng	Approva QC Inspecto
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Work Order ID 57161



Page 4

March 24, 2010	8:44:19 AM	r											1 450
Item ID: Revision ID:	D206-642-3	41				Accept				S	Setup Sta	rt	
Item Name:	Replacement	Skidtube									Sto	p	
Start Date:	24/03/2010	Start Qt	y: 1.00				Cust Item I	D:					
Required Date	: 07/04/2010	Req'd Q	ty: 1.00				Customer:						
Reference:													
Approvals:	Process Pla	an:	-	Date:		Tooling:	Da	ate:		F	Run Sta		
	QC:			Date:		SPC (Y/N):	Da	ate:			Sto)p	
Sequence ID/ Work Center I	D	Operatio Descripti				Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
		QC5- Inspe		oleteness to step on	W/O	0.00 Side	131			(X)		_	
QC Quality Control			Memo .	1		0.00	•	•					
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				4			١.	. •					
150		Skidtubes				0.00							
Skidtubes			Memo	·		0.00							
Skidtubes			and Dwg I other side.	QSI 005 and Insert D2650. Remember t Use aluminum rod uminum Rod□/	to back d	t spacers D2649. Weld as rill each hole to 0.25" befo 507	s per QSI 004 ore welding the BE 1963	/31					
!			2-Grind we Skidtube	elds flush as per Dw	vg D2650	. Masking Tape access to	inside of the	1 m					
			3-Counterl	oore 5/16" x 0.750"	deep as p	oer Dwg D2650Deburr	>	<u> </u>	1C	7-4-	6		

4- Install nut plate as per dwg

	rospace Lt	a			W 1						
W/O:				WC	RK ORDER CHANG	GES				4	•
DATE	STEP		PR	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
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Part No		The state of the s			gory:						
	Resolution:			Disposition	າ:	QA: N/C	Clos	ed:		Date: _	
NCR:				WORK ORDI	R NON-CONFORM	ANCE (NO	R)				
DATE	OTED	Description of	of NC	Corrective Action		tion B		Verific	cation	Approval	
DATE	STEP	Section A		Initial Chief Eng	Action Description Chief Eng	Sigr Dat		Secti		Chief Eng	Approva QC Inspect
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Work Order ID 57161

March 24, 2010 8:44:19 AM



Page 5

Item ID:

D206-642-341

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 07/04/2010

Replacement Skidtube

Start Date:

24/03/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Date:

Tooling:

Date:

Run Start



SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

160

HandFinish Hand Finishing Operation Description Set Up/ **Run Hours** Draw Number Draw Plan Rev. Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

HandFinishing

Memo

0.00

Install D2680-041 Nut Plate as per Dwg D2650

Date: _____

N/A done on sey#150 DP 10-4-6

170

QC Quality Control QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

Dart Ae	rospace L	td						,
W/O:			1	WORK ORDER CHAN	GES		· · · · · · · · · · · · · · · · · · ·	
DATE	STEP		PROCEDURE C	DURE CHANGE		Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No);	PAR #:	Fault C	ategory:	NCR: Yes	No DQA:	Date: _	
	Resc	olution:	Disposi	ition:	QA: N/C Clo	osed:	Date: _	
NCR:			WORK OF	RDER NON-CONFORM	MANCE (NCR)		
DATE	STEP	Description of NC Section A	Initial	Corrective Action Saction Description	ection B	Verification	Approval	Approva
		Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspecto
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Work Order ID 57161

March 24, 2010 8:44:19 AM



Page 6

Item ID:

D206-642-341

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

24/03/2010

Start Oty: 1.00

Required Date: 07/04/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference: Approvals:

Process Plan: Date:

Date:

Tooling:

0.00

SPC (Y/N):

Date:

Date: ____

Start Run



Stop

Sequence ID/ Work Center ID

190



HandFinish

Hand Finishing

Operation **Description**

Pressure Wash per QSI005 4.3

Set Up/ **Run Hours**

Draw Number

Draw Plan Rev. Code

Accept Otv

Reject Otv

Reject Insp. Number Stamp

Memo
0.00

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in

10-4-7

200



Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

1/1/13/70

0.00

=) Ju 10/04/07 XI &

Memo

START TIME: (D: 30AM

OVEN TEMPERATURE: 32
FINISH TIME: 11:00 4

210



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

D. St 10-4-19.

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr OC Inspector OC Inspector

Part No:	Р	AR #: Fault Category: _	NCR: Yes No	DQA: Date:
	Resolution:	Disposition:	QA: N/C Closed	d: Date:
NCR:		WORK ORDER NO	ON-CONFORMANCE (NCR)	

NCH:	-		WOTH ONDER HON-CONTONWANCE (NCH)								
		Description	of NC		Corrective Action Section	В	Verification	A			
DATE	STEP	Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspector		
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Work Order ID 57161

March 24, 2010 8:44:19 AM



Page 7

Item ID:

D206-642-341

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

24/03/2010

Start Oty: 1.00

Operation

Description

Required Date: 07/04/2010

Reg'd Qty: 1.00



Cust Item ID:

Customer:

Draw

Number

Reference: Approvals:

Process Plan: Date: Tooling:

Date:

Draw

Rev.

Plan

Code

Run Start

Reject

Qty

Reject

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Number Stamp

Insp.

Sequence ID/ **Work Center ID**

220

HandFinish Hand Finishing

HandFinishing Memo

0.00

0.00

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside

insert holes before installing wearnad/wearplate.

A/R□□Sikaflex-291

Sikaflex expiry date:□

Sikaflex expiry date:□

Sikaflex expiry date:□

Sikaflex expiry date:□

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R□□Sikaflex-291□

Sikaflex expiry date: [10/0 8.

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 \Box Batch: $\cancel{M}\cancel{135}\cancel{5}\cancel{5}$

Accept

Qty

bf 10-4-19 D.

Dart Ae	rospace	Ltd									•
W/O:				W	ORK ORDER CH	ANGES				1	
DATE	STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approve QC Inspect
Part No	:	P/	AR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	Date: _	
	Re	solution:		Dispositi	on:	QA	: N/C C	losed:		Date: _	
NCR:				WORK ORE	ER NON-CONFO	RMANCE	E (NC	R)			
DATE	0.750	Description	of NC		Corrective Action	Section B		Verific	ation	Anneoval	Annua
DATE	STEP	Section A		Initial Chief Eng	Action Descrip	otion	Sign Date	& Secti		Approval Chief Eng	Approva QC Inspect
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Work Order ID 57161

March 24, 2010 8:44:19 AM



Page 8

Item ID: D206-642-341 Accept Setup Start **Revision ID:** Stop Item Name: Replacement Skidtube Start Date: 24/03/2010 Start Qty: 1.00 **Cust Item ID: Required Date:** 07/04/2010 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: Tooling: Approvals: Date: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Plan Draw Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Number Rev. Code Qty Qty Number Stamp 230 QC3- Inspect Part Finish 0.00 Memo Quality Control فالراء وولو 240 QC5- Inspect part completeness to step on W/O 0.00 QC Memo Quality Control 250 0.00 Packaging Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-642-341

11/4/2 (()

Dart Ae	rospace Li	td						,
W/O:			WC	RK ORDER CHANG	ES		Ť	
DATE	STEP	PF	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Resc	olution:	Disposition	າ:	_ QA: N/C Ci	osed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	3)		
DATE	OTED	Description of NC		Corrective Action Section	on B	Verification	Approval	Annrova
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approva QC Inspect
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Work Order ID 57161

March 24, 2010 8:44:19 AM



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Item ID:

D206-642-341

Accept

Setup Start



Item Name:

Revision ID:

Replacement Skidtube

Start Date:

Required Date: 07/04/2010

24/03/2010

Start Qty: 1.00

Operation

Description

Req'd Qty: 1.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date: _____

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop





Sequence ID/ **Work Center ID**

260

Memo

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Draw Plan Rev. Code Qty

Accept

Reject Qty

Reject Insp. Number Stamp

Quality Control

0.00

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W/O:			WORK ORDER CHANGES										
DATE	STEP		PR	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto		
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Part No):	Р	AR #:	Fault Cate	jory:	N	CR: Yes	No DQ	A:	Date: _			
	Res	olution:		Disposition: G				QA: N/C Closed: Date:					
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DATE	STEP	Description	of NC	Corrective Action Section B			Ci e	Verific	fication Approva	Approval	l Approva		
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Picklist Print Page 1 March 24, 2010 8:44:23 AM Work Order ID: 57161 D206-642-341 Parent Item: Parent Item Name: Replacement Skidtube Start Date: 24/03/2010 Required Date: 07/04/2010 **Comments:** IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM Start Oty: 1.00 Required Qty: 1.00 IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-03-02 as per DSI9440 rev.a DD verified by:EC Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Qty Date AN960JD416 Status Purchased No Each 8.0000 1.0000 Washer Warehouse Loc Qty Loc Code Location Bl 10-4-20. 113706 NAS 1149 DO 463J Main Warehouse ST357 111279 CCR264SS3-3 Purchased No Each 513.0000 2.0000 Cherry Rivet Warehouse Loc Qty Loc Code Location Main Warehouse ST311 513 111548 16 111827 112314 113539 6 113973 488 CR3212-4-03 Purchased No Each 236.0000 2.0000 Cherry Rivet Warehouse Loc Qty Loc Code **Location**

Dart Ae	rospace L	td							•		•
W/O:				WORK ORDER CHANGES						*	
DATE	STEP		PR	PROCEDURE CHANGE				Date C	Appr Chief Prod	Eng /	Appròva QC Inspecto
Part No	Part No:		PAR #:	Fault Categ	ory:	NCR: Y	es No	o DQA: _	Da	te:	
			Disposition:			_ QA: N/C	Clos	ed:	Da	te:	
NCR:				WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
DATE	OTED	Description	of NC		Corrective Action Sec	tion B	·	Verificati	on Appr	oval	Approva
DATE	STEP	Section		Initial Chief Eng	Action Description Chief Eng		ın & ate	Section C			QC Inspect
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March 24, 2010 8:44:23 AM

Work Order ID: 57161

Parent Item:

D206-642-341

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev: H \square 05.10.11 \square Added D3429-1 per CHG004 \square KJ/CP/JLM

Manufactured

Start Date: 24/03/2010

Required Date: 07/04/2010

	IPP Rev:I 08-09-03-02 as per DSI	29 revF as per d	wσ Γ	D verified by	/CP/JLM /:EC Est F	Rev:J 09-			Start Qty: 1.00)	Required Qty:	1.00
Component Item ID/ D2620 Skidtube, 206 Skidtube	Replacement		Bin	Primary	Last	Route	Unit of Each	Qty on 8.0000	Remaining	Qty	Date	Status
				<u>Warehoo</u> <u>Loca</u> Main Wa	tion	Loc (<u>Oty</u>	Loc Code)/0	5-3-3	
D2647		Manufactured	No	LG	55559		8 8 Each	87.0000	1.0000			0

Warehouse Loc Oty Loc Code Location Main Warehouse FP 87 BE 10-3-30 55352 87 Each 207.0000 19.0000

D2649 Cross Bolt Spacer

		1 1 02 /1 / 1/0 /	
Warehouse Location	Loc Oty	Loc Code	
Main Warehouse			
LG	207		
36013	5		
47112	18		 •
48271	4		
51529	3	\mathcal{A}	
55000	177	4	 BE 10/03/31

Dart Aerospace L	_td
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W/O: WORK ORDER CHA					IGES				•	, , , , , , , , , , , , , , , , , , ,		
DATE	STEP		PR	OCEDURE CH	ANGE	E	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		AR #: Fault Category: NC										
Resolution:				WORK ORDER NON-CONFORMANCE								
NCR:				WORK ORI	DER NON-CONFORI	MANCE (I	NCR))				
DATE	STEP	Description Section		Initial Chief Eng	Corrective Action S Action Descriptio Chief Eng		ign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector	
				Office Eng	Officer Eng		Date				-	
			*							:		
			-									

Picklist Print

March 24, 2010 8:44:23 AM

Page 3

Work Order ID: 57161

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H \square 05.10.11 \square Added D3429-1 per CHG004 \square KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DSI9440 rev.a DD verified by:EC



Start Date: 24/03/2010

Required Date: 07/04/2010

Required Qty: 1.00

Component Item ID/ D2654-5

Replacement Mfg/

Manufactured

Manufactured

Bin Primary

No

Last

Route

Unit of Each

Qty on 2.0000

Remaining 1.0000

Start Qty: 1.00

Qty

Date

Status

Web

Warehouse

Loc Code

Location

Main Warehouse

LG

46638

2

Each

Loc Oty

51.0000 1.0000

D2680-041

Nut Plate

Warehouse

Location

Main Warehouse

ST021

33061 55366 Loc Oty

51

50

Loc Code

ALS4-1032-130

Purchased

Insert

No

220

Each

438.0000 54.0000

Warehouse **Location** Loc Qty

Loc Code

Main Warehouse

ST282 /144107 110511

438

438

54. BR 10-4-20.

March 24, 2010 8:44:23 AM

Shop Packet Print

Page 3

Dart Ae												
W/O:				WORK ORDER CHANGES								
DATE STEP			PR	IGE		Ву	Date	ate Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto		
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		PAR #:	AR #: Fault Category: No			: Yes	No DQ	A:	Date: _			
		lution:	Disposition:			QA: N/C Closed: Date: _						
NCR:				WORK ORDE	R NON-CONFORM	ANCE	/NICE					
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DATE	STEP	Description Section	of NC			ction B	Sign 8	Verific	cation ion C	Approval Chief Eng		
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DATE	STEP	Description Section	of NC	Initial	Corrective Action Sec Action Description	ction B	Sign 8	Verific				
DATE	STEP	Description Section	of NC	Initial	Corrective Action Sec Action Description	ction B	Sign 8	Verific				

March 24, 2010 8:44:23 AM

Work Order ID: 57161

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H \square 05.10.11 \square Added D3429-1 per CHG004 \square KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DSI9440 rev.a DD verified by:EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Required Qty: 1.00

Component Item ID/

AN960C10L

Replacement Mfg/

Purchased

Bin Primary No

Last

Route 220

Unit of Each

Qty on 0.0000

Remaining 54.0000

Start Qty: 1.00

Qty

Date Status

washer

AN960JD10L

Washer

Purchased

No

220

NAS149C0332R.

Each

3,003.000 2.0000

Loc Code

Location Main Warehouse ST348

Warehouse

101291 105793 110985 3003 16 49

Loc Oty

2938 Each 2 bk 10-4-20

D2646 Aft Cap

Manufactured No

220

41.0000 1.0000

Warehouse Loc Oty Loc Code Location Main Warehouse FP6 36 46327 T BR 10-4-20 48109 4 52663 28 Main Warehouse fp7 5 52663 5

Dart Ae	rospace	Ltd									,	
W/O:			WORK ORDER CHANGES									
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Picklist Print

March 24, 2010 8:44:23 AM

Work Order ID: 57161

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H \square 05.10.11 \square Added D3429-1 per CHG004 \square KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DSI9440 rev.a DD verified by:EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00 Required Qty: 1.00

Component Item ID/	R
D2651-1	

Replacement Mfg/ Manufactured

Bin Primary No

Last

Route 220

Unit of Each

Each

Loc Code

Qty on Remaining 348.0000 14.0000

Qty

Date

-14 Bl 10-4-20.

Status

Page 5

Plug

Warehouse Location	Loc Oty
Main Warehouse	
FP	141
51530	141
Main Want	

Main Warehouse

fpa 53349

207 207 220

537.0000 14.0000

D2651-3 O-Ring

Manufactured

Warehouse Loc Oty Loc Code Location Main Warehouse FP 537 43849 3 46114 534

14. St 10-4-20.

	rospace Lt	d										
W/O:	_			WO	RK ORDER CHA	NGES					, ,,	
DATE	STEP		PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect	
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March 24, 2010 8:44:23 AM

Work Order ID: 57161

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-03-02 as per DSI9440 rev.a DD verified by:EC

Start Date: 24/03/2010

Start Qty: 1.00

Required Date: 07/04/2010

Required Qty: 1.00

Date

Component Item ID/ D3535-11

Replacement Mfg/ Manufactured

Bin Primary No

Last

Route 220

Unit of Each

Qty on 6.0000 1.0000

Remaining

Otv

Status

Wearshoe

Warehouse Location

Main Warehouse

FP

220 Each

Loc Oty

14.0000 1.0000 -BR 10-4-20

D3535-23

Wearshoe

No

Loc Code

Warehouse Loc Oty Loc Code Location Main Warehouse FP 14 53467 2 56054 12 220 Each 9.0000 1.0000

1 BR 10-4-20

D3535-35



Manufactured

Manufactured

Warehouse Location

Main Warehouse

FP

51608

Loc Qty

Loc Code

9

- bl 10-4-20.

Dart Ae	rospace L	_td									
W/O:				WC	RK ORDER CHANG	ES			· •		,
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March 24, 2010 8:44:23 AM

Work Order ID: 57161

Parent Item:

D206-642-341

Parent Item Name: Replacement Skidtube

Comments:

D3536-23

Gasket

D3536-35

Gasket

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

Manufactured No

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DS19440 rev.a DD verified by:EC



Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

		P		-,,								
Component Item ID/ D3536-11 Gasket	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 220	Unit of Each	Qty on 14.0000	Remaining	Qty	Date	Status

Warehouse Location	<u>Lo</u>	c Oty	Loc Code			ı
Main Warehouse					1.0	
ST497A /		14				
46649		10			1 15-16-4-20	
46715		4				
	220	Each	8.0000	1.0000	,	
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6: :							
		Warchouse Location	Lo	oc Oty	Loc Code		
		Main Warehouse FP 30754 53468		8 1 7			
Manufactured	No		220	Each	11.0000	1.0000	

<u>Warehouse</u>	Loc Oty	Loc Code	
Location	•		
Main Warehouse			
FP)	11		00
51628	. 11		1 / 10-4-20.
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Dart Ae	rospac	- I +d						*		
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Picklist Print

March 24, 2010 8:44:23 AM

Work Order ID: 57161

Parent Item:

D206-642-341

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev: H□05.10.11 □ Added D3429-1 per CHG004 □ KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DSI9440 rev.a DD verified by:EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3537-1

Replacement Mfg/

Manufactured

Bin Primary

Last

Route 220

Unit of Each

Qty on 53.0000 6.0000

Remaining

Qty

Date

6. ph 10-4-20

Status

Page 8

Wearpad

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP 57510	52	
48288	2	
55465	50	
Main Warehouse		
FP17	1	
51678	1	

Manufactured

35697

Each

4

20

24.0000

1.0000

Warehouse Loc Qty Loc Code Location Main Warehouse 24

220

1 ph 10-4-20.

March 24, 2010 8:44:23 AM

Shop Packet Print

Page 8

W/O:				WORK ORDER	CHANGES				•	,
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Picklist Print

March 24, 2010 8:44:23 AM

Work Order ID: 57161

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev: $H \square 05.10.11 \square$ Added D3429-1 per CHG004 \square KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-

03-02 as per DSI9440 rev.a DD verified by:EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Page 9

Start Qty: 1.00

Qty

Required Qty: 1.00

Component Item ID/ MS27039-1-08

Replacement Mfg/

Purchased

Bin Primary No

Last

Route 220

Unit of Each

Qty on Remaining

2,105.000 56.0000

Date Status

Screw

Screw

Warehouse Loc Qty Loc Code Location Main Warehouse ST291 2105 3 110467 102 2000 110835 220

MS27039-4-06

Purchased

No

Each

38.0000 1.0000

Warehouse Loc Qty Loc Code Location

Main Warehouse

ST292 109061 38 38 ff 10-4-20.

56. H16-4-20.

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QTY QTY QTY QTY DESCRIPTION PART NUMBER SKIDTUBE ASSEMBLY D2650-1 Х SKIDTUBE ASSEMBLY D2650-3 Х SKIDTUBE ASSEMBLY Х D2650-5 SKIDTUBE ASSEMBLY D2650-7 X D2600-1-160 EXTRUSION WEB D2654-1 D2654-3 WEB WEB D2654-5 D2654-7 WEB D2646 AFT CAP 1 CAP D2647 1 CROSS BOLT SPACER 17 18 19 23 D2649 16 18 14 22 D2651-1 PLUG 18 14 22 16 O-RING D2651-3 NUT PLATE 1 D2680-041 2 DOUBLER 2 D3286-1 D3286-3 STUD 2 2 INSERT (or AKS4-1032-130, ALS4-1032-130. ALS7-1032-130 42 44 54 60 ALS7-1032-130) AN960JD10L WASHER 2 2 2 2 RIVET 2 2 2 2 CCR264SS3-3 RIVET CR3212-4-03 2 2 2 2 SCREW 2 2 2 MS27039-1-08 2 MS27039-4-06 SCREW WASHER AN960JD416 1 RIVET 52 CR3212-4-04 52

NOTES:

D

С

1) MATERIAL: N/A

2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

9) DAMAGE TOLERANCE ON FWD BEND: THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE

GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015

11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOWCOMY RETURNIO ENGINEERSWI UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

NO 3/14/ BD10-3-24

3 No.

DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED, ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6, SHT 1 IN PL PART D2649 QTY AJS 08.08.08 UPDATED, SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239). RMOVE CBORE, CHG DRILL, ADD CHAMFER CP 06.03.30 E REDRAW; INCORP. DE09136/9153/9163 CP 04.05.17 MOD GROUND HANDLING ON D2650-1/-3 CHANGE HOLE PATTERN AND FRONT END DS 97.10.29 С 97.06.26 B AS MANUFACTURED CHANGES DS NEW ISSUE 97.03.25 DS Α REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE USA, INC DS DRAWN PORT HADLOCK, WA AJS CHECKED DRAWING NO. REV. F D2650 SHEET 1 OF 6 MFG. APPR. APPROVED TITLE SCALE 206/407 SKIDTUBE ASSEMBLIES NTS DE APPR. COPYRIGHT © 1997 BY DART AEROSPACE USA, INC DATE 08.08.08

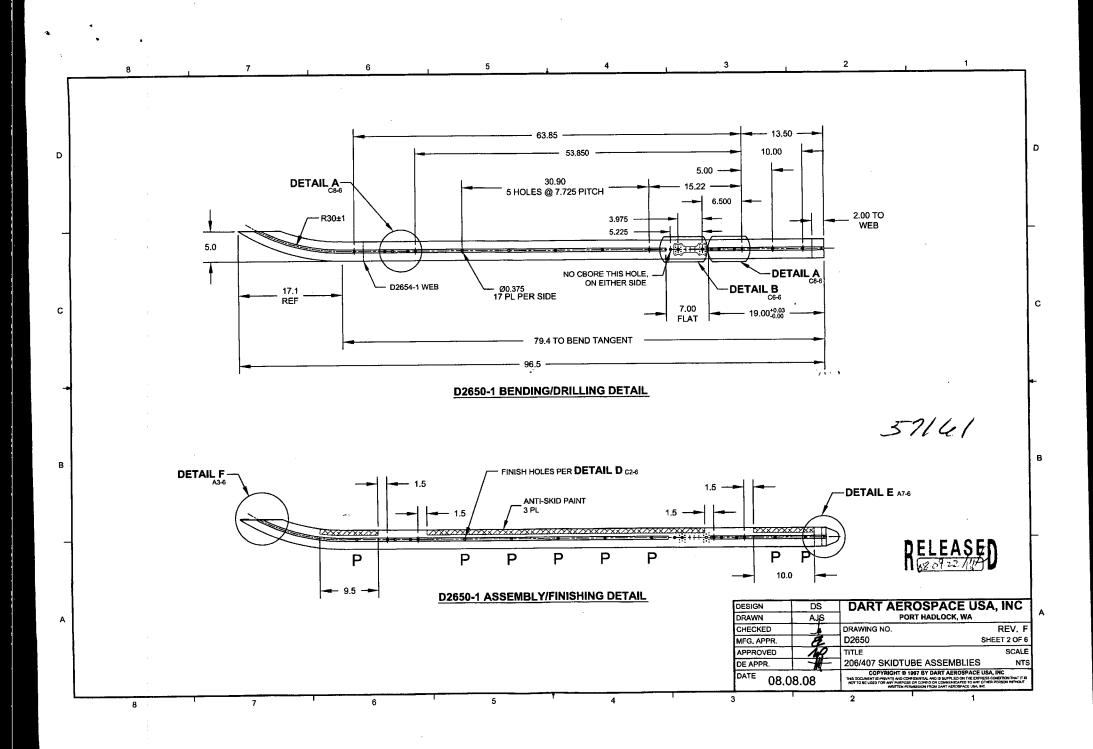
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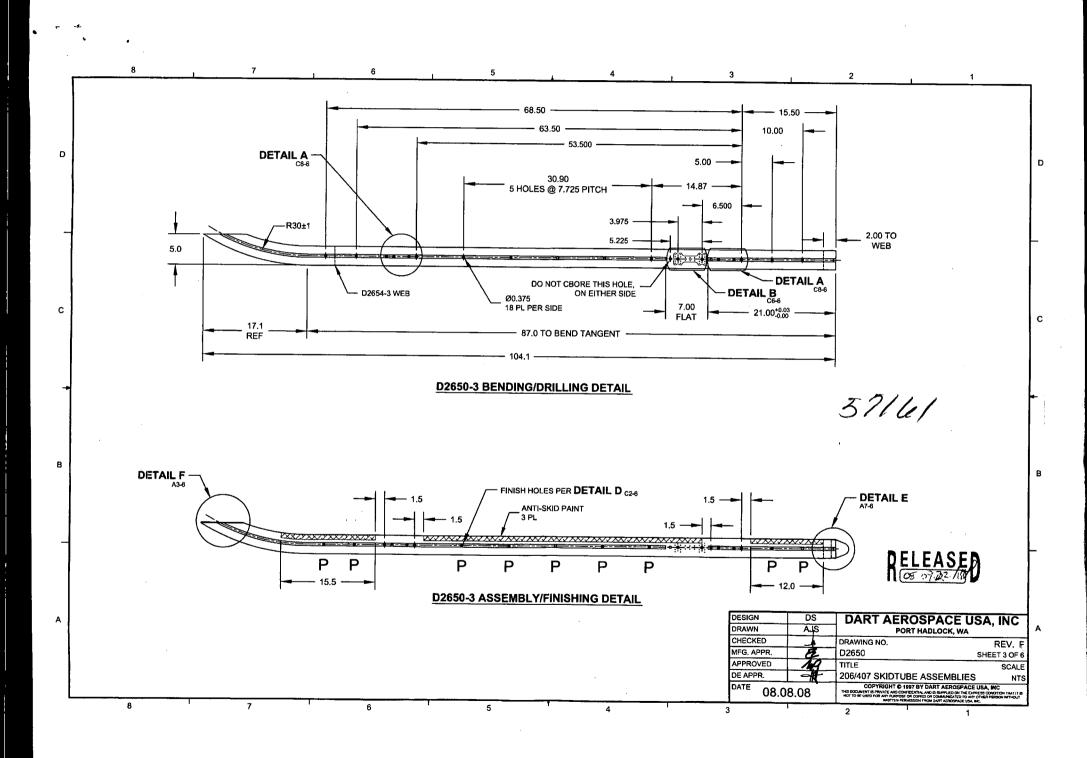
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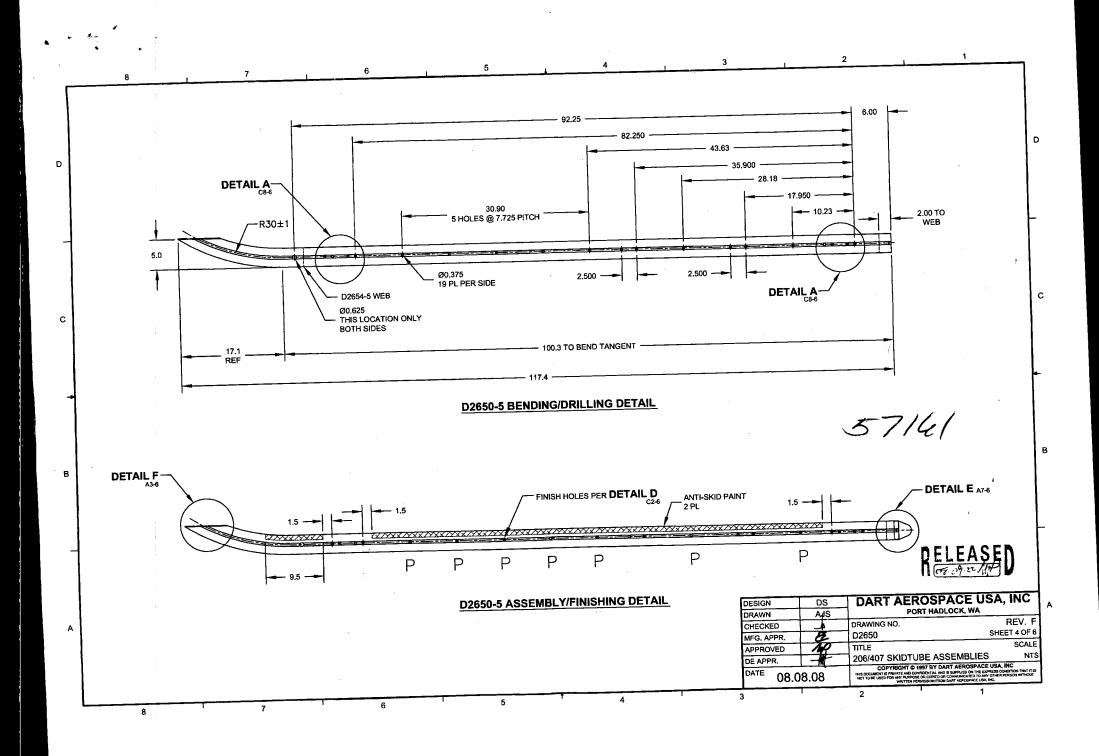
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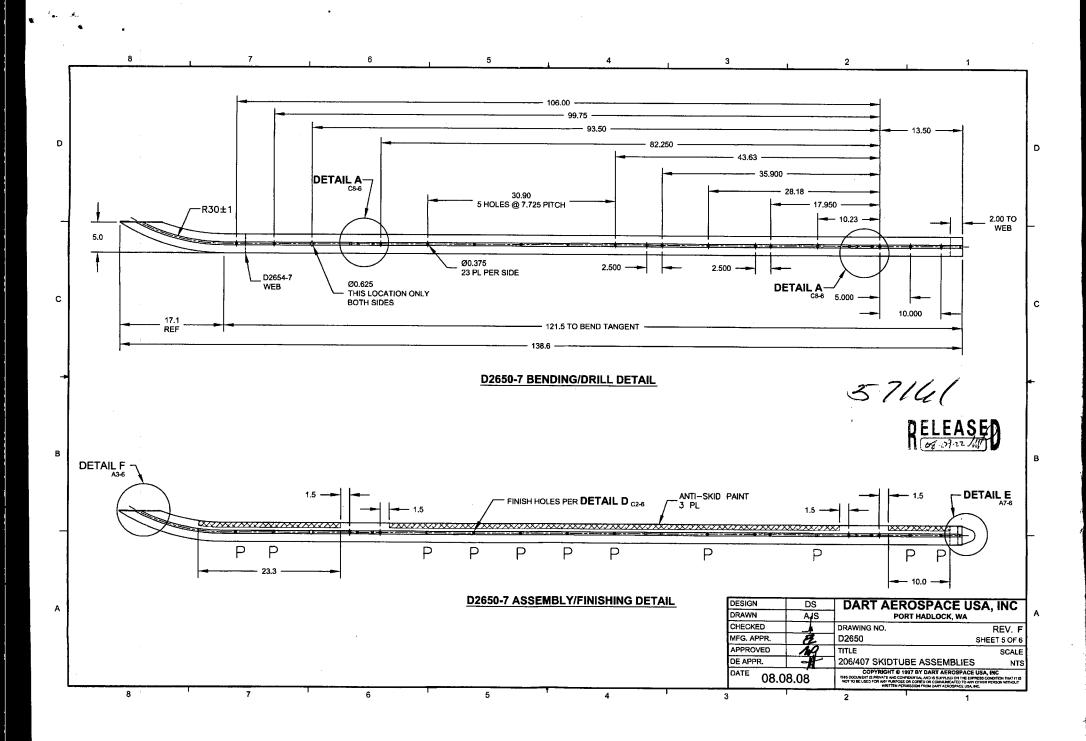


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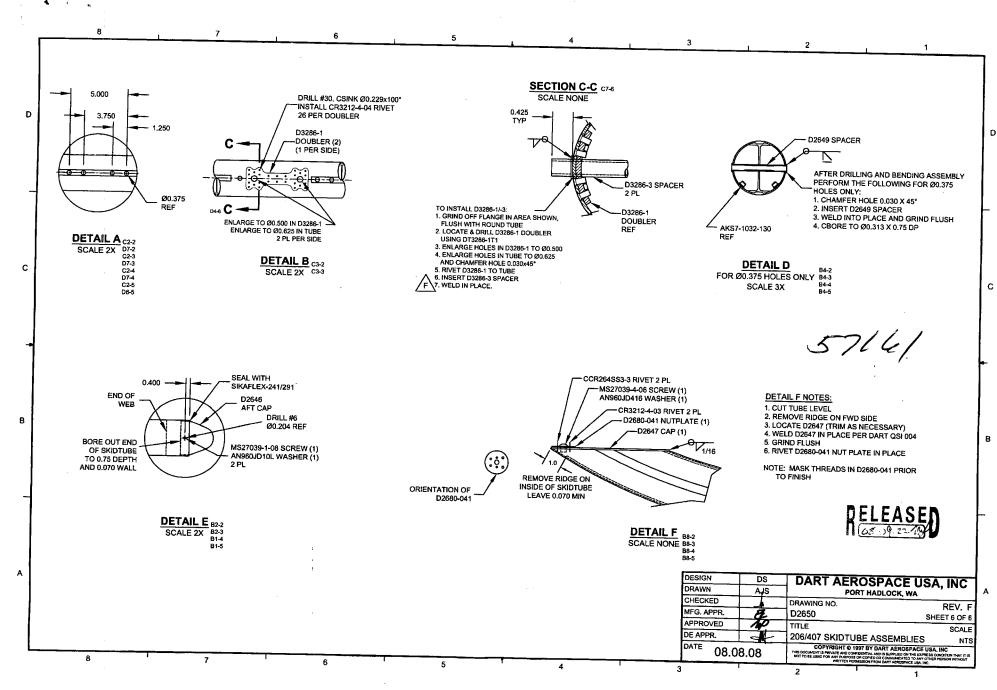


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NO. 323

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Parcla; Elliott
Job number: 18 5577
Part number: 0206-642-441
Description: 206 stid tube
Welding Process: Tig[/ Mig[]
Base materiel: Aluminian
Current: AC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[/] fail[]
Penetration:	pass[´] fail[]
UNACCEPTABLE	
Cracks:	pass[/ fail[]
Undercut:	pass[/] fail[]
Pin holes:	pass[/ fail[]
Overlap (cold lap)	pass[/] fail[]
Porosity (surface):	pass[/]/ fail[]
Coloration:	pass[] fail[]
Qualifier Lat. Sal	Date of Test Coupon 18.02.16
Welder Dorcha Client	Date of Test Coupon 10-02-16
The above named individual is quali	fied in accordance with AWS D17 1 2001 to a